

Date: Thursday, 2/22/2007 2:57:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 30809	
Estimate Number : 10001	
P.O. Number : <i>N/A</i>	Part Number : D2213
This Issue : 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2213 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30107	Material : <i>N/A</i>
Written By : _____	Due Date : 3/20/2007 Qty: 160 Um: Each
Checked & Approved By : <i>07.02.23</i>	
Comment : Est Rev: 0 Turned In-House 05-10-17 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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W 07.05.23
 Comment: Qty.: 1,1000 in(s)/Unit Total : 176.0000 in(s)

MATERIAL: 6061-T6 Round Bar .750"

(M6061T6R0750)

Batch: *M 103355**DSP 07/05/19*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA113 & DWG D2213,

FOLIO REV: *B*DWG REV: *B*

2-DEBURR AS REQUIRED

DSP 07/05/19 (175)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DSP 07/05/19**175*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*BC 07-09-22**175*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/05/22 (175)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 07/05/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 30809

Part Number: D2213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8F20

U

7/5/23

sq

(175)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(175)

Comment: FINAL INSPECTION/W/O RELEASE

Notes 123

Job Completion



U 8FWS23

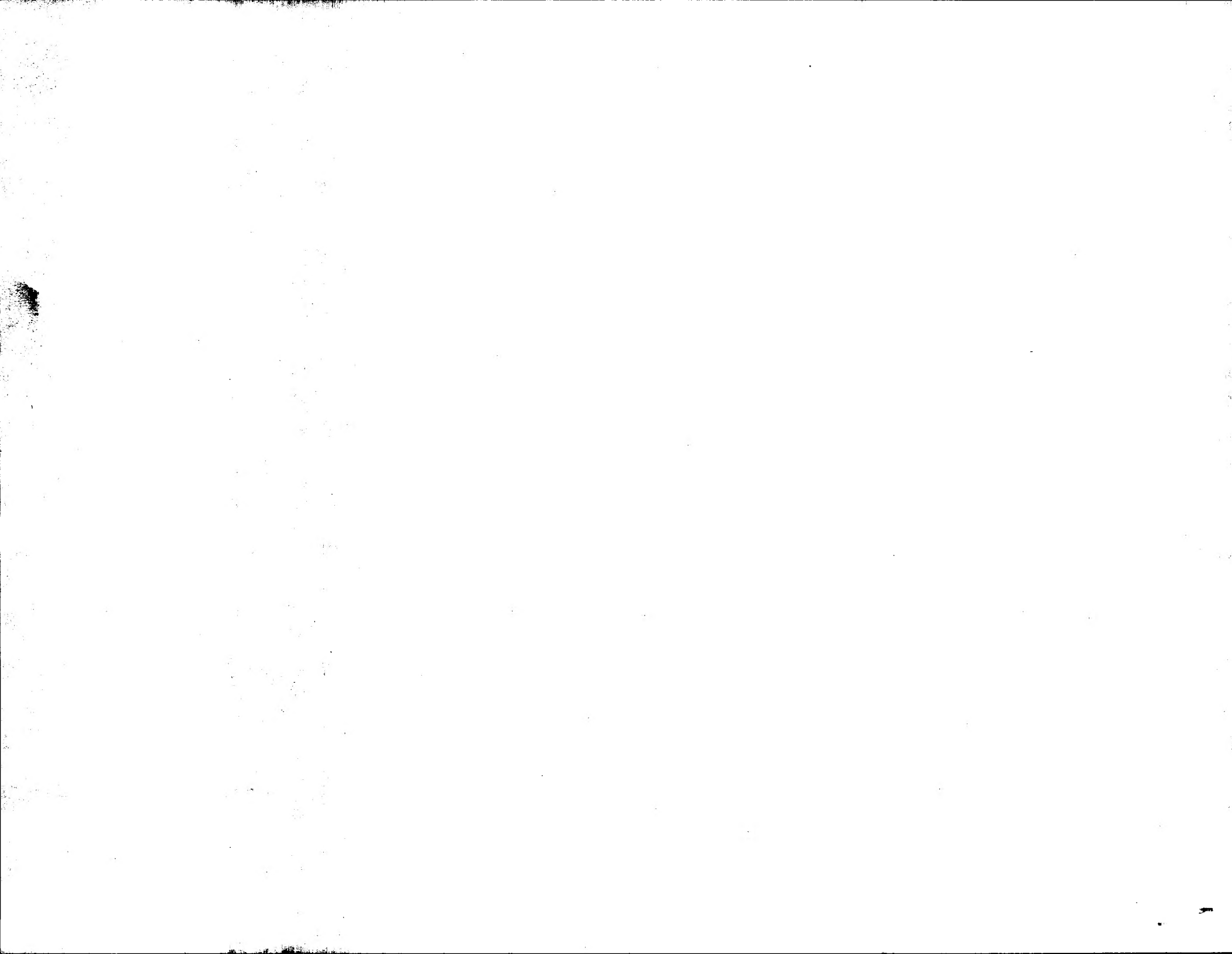
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

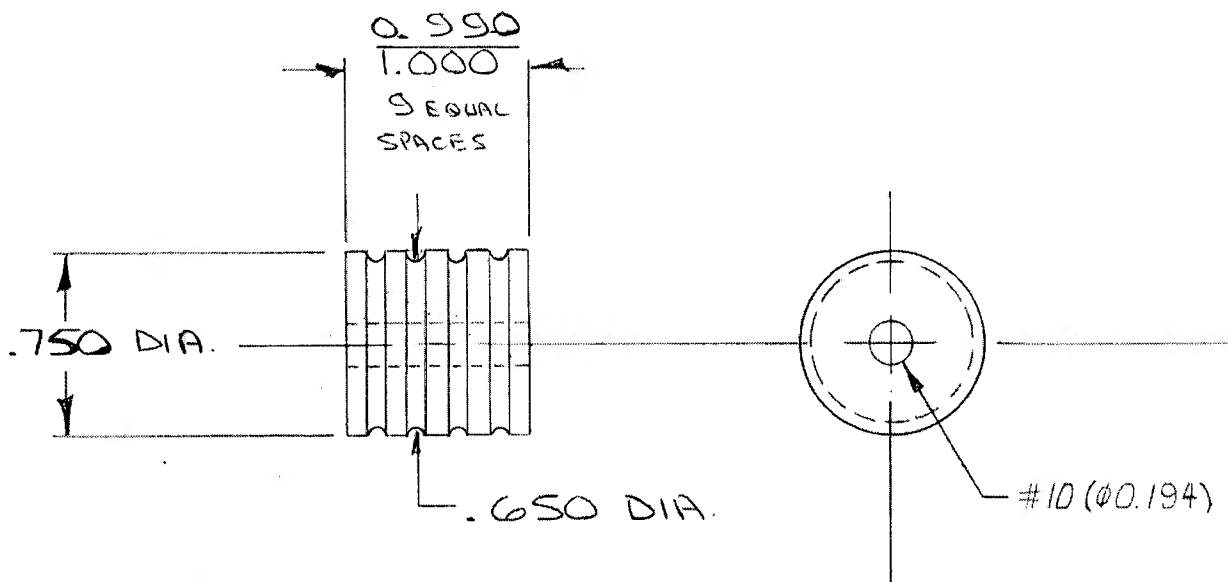
NOTE: Date & initial all entries



DART



DRAWN BRADLEY 94.2.9		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.2.9		DRAWING NO. DZZ13	REV. B
STRESS		TITLE SPACER	
B	95:08:17	#10 HOLE ADDED	



MATERIAL

ALUMINUM ALLOY 2011-T3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30809